

Split

Work Order ID 74111-1

Wednesday, September 21, 2011 3:10:49 PM



Page 1

Item ID: D3286-1

Accept



Setup

Start



Revision ID:

Stop



Item Name: Doubler

20

Start Date: 9/21/2011 Start Qty: 80.00



Cust Item ID:

Required Date: 10/3/2011 Req'd Qty: 80.00



Customer:

Reference:

Approvals: Process Plan: *✓*

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr Revision Nbr

D3286 Rev A
109

FLOW WATER JET

0.00

FB11-9-21

Waterjet
FLOW CNC Waterjet
304 .125
1-Cut as per Dwg D3286
Dwg Rev: *A*
Prog Rev: *A*
2-Deburr if necessary

0.00

88

110 QC2- Inspect parts off machine FAI/FAIB

QC

0.00

FB11-9-21

Quality Control

120 QC8- Inspect parts - second check

QC

0.00

Silvazz

Quality Control

*688
counter*

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Stop



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Cust Item ID:

Required Date: 10/3/2011 Req'd Qty: 80.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Step

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

0.00

Memo

0.00

SB 11/09/22

20

Form as per Dwg D3286

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

5 11/09/23

counts
20

Memo

0.00

150



Packaging

Packaging

Identify as per dwg & Stock Location: L4

0.00

Memo

0.00

STOCK IN SKIDTUBE CELL

11/09/23 20

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Item ID: D3286-1

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 9/21/2011 Start Qty: 80.00



Cust Item ID:

Required Date: 10/3/2011 Req'd Qty: 80.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Memo

0.00

11/9/21
MF
11-09-23

Picklist Print

Wednesday, September 21, 2011 3:10:46 PM

Page 1

Work Order ID: 74111



Parent Item: D3286-1



Parent Item Name: Doubler

Start Date: 9/21/2011

Required Date: 10/3/2011

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP A 04.07.14 New issue KJ/JLM
IPP Rev:B Now on Waterjet 06-06-16 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 		Purchased	No			100	sf	23.0000	0.0749	6.307368	6.6		

304/316 0.125 Sheet

Location	Loc Qty	Loc Code
MAT020	23	
117494	23	

117494

(88)

DART AEROSPACE LTD	Work Order:	W/111
Description: Doubler	Part Number:	D3286-1
Inspection Dwg: D3286	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	R
Date:	11-9-21

Audited by: J
Date: 11/05/22

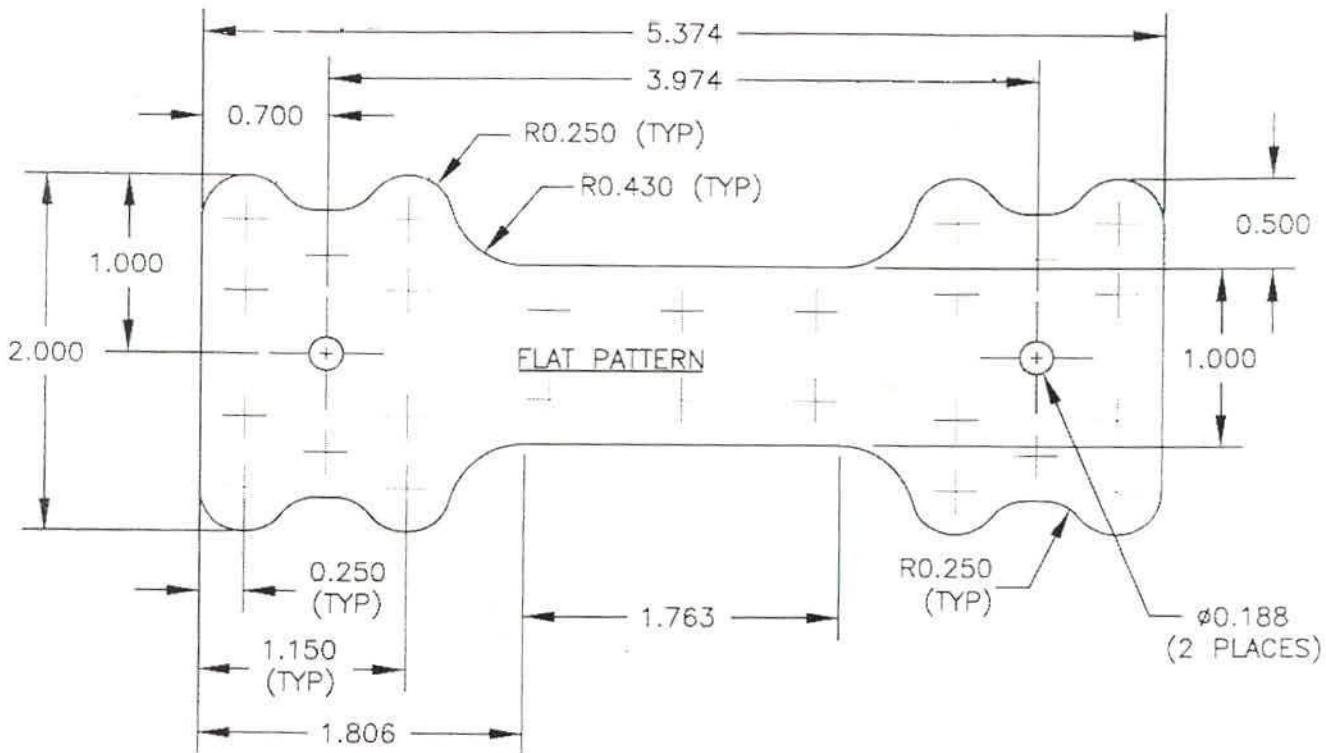
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.11.07	New Issue	KJ/JLM	E



COPY ISSUED
10/10/06

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3286	SHEET 1 OF 2
DATE		TITLE	SCALE
04.05.06		GROUND HANDLING PARTS	1:1
A	04.05.06	NEW ISSUE	



+ INDICATES LOCATION OF RIVET HOLES. SHOWN FOR REFERENCE ONLY, DO NOT DRILL.

RELEASED
10/10/06

D3286-1 DOUBLER

- 1) MATERIAL: AISI 304/316 SS SHEET 0.125" THICK
(REF DART SPEC. M304S11GA)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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